

Work Order ID 137186

137186

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Thursday, September 24, 2015 2:12:03 PM

Item ID: D3270-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fuel Scupper Assembly
Start Date: 9/23/15 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/23/15 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MLJ Date: SEP 25 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3270	Rev B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Cut D3270-3 as per Dwg D3270								

110	Large Fab	0.01							
110									
Large Fab	Memo	0.01							
Large Fab	Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.								

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

2 FF SEP 30 2015

2 EL 16-02-12

2 16-02-13 DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>2</u>	<u>16-02-18</u>		<u>9</u> 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>2</u>	<u>16-2-18</u>		<u>34</u> 9-89
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>m 133962</u> Memo START Time: <u>2:35</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>3:05</u>	0.00 0.00				<u>2</u>	<u>16-02-18</u>		<u>34</u> 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									DAS
QC	Memo	0.00							38
Quality Control									FEB 22 2016
165	Identify as per dwg & Stock Location: <u>5029</u>	0.00							
165									
Packaging	Memo	0.00							2
Packaging									MLJ 16-02-22
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							MLJ
Quality Control									FEB 24 2016

MLJ FEB 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

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Work Order ID: 137186

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Parent Item: D3270-041

D3270-041

Parent Item Name: Fuel Scupper Assembly

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3270-1		Manufactured	No			100	Each	41.0000	1	2			
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D3270-1

Mounting Base

FF SEP 30 2015

Location

Loc Qty

Loc Code

WA002

41

130540

41

2

M6061T6T0.375W.035

Purchased

No

100

f

96.7467

0.6666

1.403368

M6061T6T0.375W.035

6061-T6 RD Tube .375 x.035W

FF SEP 30 2015

Location

Loc Qty

Loc Code

MAT013

96.7467

124491

64.5

m130071

32.2467

1.4033

DQA: _____ Date: _____



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